Work Ord March-28-13 1		12		*991	112*							Page 1
Item ID: Revision ID:	D3898-1	(20(1))		Accept	*N900	040	100) * :	Setup	Start Stop	1 41	S1* S2*
Item Name:	Floor Protector		at a di							•	17	57"
Start Date: Required Date Reference:	3/22/13 e: 3/27/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	ID:						
Approvals:		1: MC5				ate:		1	Run	Start Stop	*N	R1*
	QC:		Date:	_ SPC (Y/N):		ate:					" \	R2*
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr										
D3898	Rev	A										
*100 *100* HandThermo				0.00							AE.	13/04/09
Hand Finishing Th	nermoforming	Memo 1-Cut Shee	to required Blank size	0.00								
105				0.00						•-		; /
105		Dry material										13/04/09
HandThermo		Memo		0.00							7	1-3-7
Hand Finishing Th	nermoforming	Dry Sheet a	is per QSI022 POLYCAR	BONATE								

Temp:____

Time IN: 4:30
Time OUT: 7:00

										DQA:	bate:	
NCR: Y	es /	No			WORK ORDER NO	ON-COI	NFORM	MANCE / UP	DATE		,	
										QA Closed:	Date:	
Work Orde	ŕ:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N					Rewo Scra	ар 🔲 📗	r	Skid-tube Machining noforming	Crosstube Small Fab Finishing	•	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	o				Work Order Upda			Large Fab	Composite	Nec/3to	Supplier	Other
Root					Description of work order upd	ate I	Initial	Ac	tion	Sign &	,	
Cause		Date	Step	Qty	or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	_					ĺ						
Equip/Tooling	_											
Operator				,	·						į	•
Material	_										!	
Setup	_						l				į.	
Other					,						1	
Process											İ	
Supplier												
Training												
Unapproved					'							
						FAUL	T CATE	GORY			,	
Landin	g Ge	ar			General	,						

Pressure/Forced Bending Bend Grain Ovalized BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Broken/Damaged Part Incorrect Weld Cracks Inspection Incomplete Wrong Stock Pulled Crushed/Crimped Burrs Instructions Incomplete/Unclear Part Lost/Missing Part Moved Cuffs Maintenance Contamination Mislabeled Positioned Wrong Heat Treat Countersink Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge **Drill Holes** Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Folio Outside Dimensions Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 9 March-28-13 12:46:47 PM	· ·		*991	12*						Page 2
Item ID: D3898-1 Revision ID: Item Name: Floor Prote	ctor (206L)		Accept	*N900	040	100)* s	etup Star Stop	I VI	S1* S2*
Start Date: 3/22/13 Required Date: 3/27/13 Reference:	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	(D:		٠.			
• •	Plan:	Date:			ate:		R	tun Star Stop		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Thermoform Thermoforming Machine	3-Thermofo Dwg Rev: Folio Rev:	ool to required temp. rm as per Dwg and Folio	0.00 #FTA0xxusing tool DT9501 and texture				i			B 13/04/0
140 *140* HandThermo Hand Finishing Thermoforming	Memo	nished dimensions as per	0.00				×(13/01/16
150	QC2- Inspect parts off m	achine FAI/FAIB	0.00							N .

0.00

Memo

Complete FAI document

150

Quality Control

NCR: Y	es / No				WORK ORDER NON-C	CONFO	RMANCE / UP	DATE	QA Closed:	Date	:	
Work Orde	ř:				DISPOSITION			AGAINST DE				
Part No					Rework Scrap Use-as-is Work Order Update	Th	Skid-tube Crosstube Water Jet Engineering Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Other Large Fab Composite Supplier					
Root				Descri	ption of work order update	Initia	I Ac	tion	Sign &	!		
Cause	Date	Step	Qty		or Non-conformance	Chief E	1	ription	Date	Verification	QC Inspector	
Doc/Data	-	- ССР			or trail comormance	Omer E				1		
quip/Tooling												
Operator												
Material										ī		
Setup										ı		
Other			[]							ı		
Process										F .		
Supplier	7				` ;					-		
Training										i .		
Unapproved										,		
					F	AULT CA	TEGORY					
Landin	g Gear				General					i		
	Bending				Bend	Gra	in	Γ	Ovalized	ı	Pressure/Forced	
Ī	Centre No	ot Concei	ntric to C	o/s	BOM/Route	Hard	dware		Over/Under	tolerance	Temperature/Cure	
Γ	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorred	ct '	Weld	
. [Crushed/	Crimped			Burrs	Inst	ructions Incomplete/I	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination	Mai	ntenance		Part Moved		_	
Ī	Heat Trea	nt			Countersink	Misl	abeled		Positioned V	Vrong ,		
ľ	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short	Misi	ead		Power Loss/	Surge	Other	
1	Ripples in	-			Drill Holes	Offs	et		-			
	Torque W		xtrusion	,	Drawing	Out	of Calibration			i		
	Turning S				Finish	Out	of Sequence			,		
ľ	Wave/Tw	-			Folio	Out	side Dimensions			r		

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Manah 28 13 12:46:47 PM

March-28-13 12	:46:47 PM										
Revision ID:	D3898-1 Floor Protector	r (2061)		Accept	*N900	040	100)* s	etup Star Stop	i VI -	S1* S2*
	3/22/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				IV.	
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		R	tun Star Stop	, "I V I	R1* R2*
Sequence ID/ Work Center ID 160 *160 *160* QC Quality Control 170 *170* Packaging Packaging		Operation Description QC5- Inspect part comple Memo Identify as per dwg & St		Set Up/ Run Hours 0.00 0.00 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*180 *180* QC Quality Control		QC21- Final Inspection Memo	- Work Order Release	0.00					13/	4/16) 4

R13-0414

NCR:	Yes	/	No

												DQA:	Date	e:	
NCR: Y	'es	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPD	DATE			-	
						_						QA Closed:	Date	2:	
Nork Orde	r:					١	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
	•						Rework	1		Skid-tube	Crosstube]	Water Jet	ΠE	ngineering
Part N	lo.					ı	Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	┦ ¯	Quality
	•						Use-as-is	1		noforming	Finishing	4	re/Packaging	7	Other
NCR N	lo.					İ	Work Order Update	1		Large Fab	Composite	1	Supplier	7	
								•				-	_		
Root					Desc	rip	tion of work order update	1	nitial	Acti	ion	Sign &			· - , ,
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification		QC Inspector
oc/Data		·					i								
quip/Tooling								1							
perator	_									·				İ	
faterial															
etup															
ther	\dashv														
rocess	\dashv				!										
upplier 	_														
raining	-						•								
napproved									T CATE	CORV					
Landi	20 6	Coor					General	AUL	CAIL	GORT					·
Larran		Bending			Γ		Bend	<u> </u>	Grain			Ovalized	Γ	Pre	ssure/Forced
	_	Centre No	ot Concer	ntric to (o/s	—	BOM/Route	<u> </u>	Hardwa	ire	<u> </u>	Over/Under	tolerance		nperature/Cure
		Cracks			-''- -		Broken/Damaged		1	ion Incomplete	<u> </u>	Part Incorred	-	We	•
		Crushed/0	Crimped		<u> </u>	\dashv	Burrs		1	ions Incomplete/U	nclear	Part Lost/Mi)		ong Stock Pulled
	_	Cuffs	•		F		Contamination		Mainte	•		Part Moved	· _		
i		Heat Trea	t		Ī		Countersink		Mislabe	eled		Positioned W	/rong		
		Inspection	n Strip in	Tube	ľ		Cut Too Short		Misread	d		Power Loss/S	Surge	Oth	er
		Ripples in	Bend				Drill Holes		Offset		<u> </u>				
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration					
		Turning Se	equence				Finish		Out of 9	Sequence					
		Wave/Tw	ist in Tub	e			Folio		Outside	Dimensions					

Wave/Twist in Tube

Page 1

Work Order ID:

99112

Parent Item:

D3898-1

Parent Item Name:

Floor Protector (206L)

Start Date: 3/22/13

Required Date: 3/27/13

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev.A New Issue 09/02/06 DL

10/04/21 DI

IPP RevB Add Step 105 Dry Material

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	653.4069	10.6	11.157895	;		
Levan Sheet													

Lexan Sheet

Location therm

113127

Loc Qty 653.4069406 653.406941

Loc Code

10.6

			•							DQA:	Date	2:
NCR: Ye	es / No				WORK ORDER NON-C	CON	FORM	MANCE / UPDATE		QA Closed:	 Date	· ·
Work Order	<u>.</u>				DISPOSITION			AGA	INST DE	PARTMENT,		
Part No					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube Water Jet Eng Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier						Engineering Quality Other
Root	Date	Step	Qty		iption of work order update or Non-conformance		nitial ef Eng	Action Description		Sign & Date	Verification	QC Inspector
occ/Data quip/Tooling Operator Material eetup Other Process supplier Training Unapproved												
						AULT	CATE	GORY			r	
Landin	Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspection Ripples in Torque W	Crimped at n Strip in n Bend Vaves in E	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instructi Mainte Mislabe Misread Offset Out of C	on Incomplete ions Incomplete/Unclear nance led I		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/	ssing .	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
-	Turning S Wave/Tw			-	Finish Folio	-		sequence Dimensions				
	1 *** ** ** * * * * * * * * * * * * * *				1	1 1						,

DART AEROSPAC	CE LTD		T	Wo	rk Order:	99112
Description: Floor Pr	otector			Pa	rt Number:	D3898-1
Inspection Dwg: D38	98 Rev : A			<u> </u>		Page 1 of 1
mapeonon bwg. Doo						1 age 1 or 1
	FIRST A	RTICLE INSF	PECTION	CHECK	LIST	
	X	First Article		Prototy	oe .	
	т	HERMOFORM	MING SE	CTION		
					1 Markhard - 5	T
Description			Accept	Reject	Method of Inspection	Comments
Inside Radii less than	NIA"				-	
Shape Definition			N			
Texture Retention			V			
Material imperfections	such as bumps,	cracks, voids,	./			
scratching						
						1 N. 1 N. 1 N. 1 N. 1 N. 1 N. 1 N. 1 N.
	******					1
			l			
Measured by:	ati.				Date:	13/04/09
		TRIMMING	SECTION	PN		
Drawing		Actual			Method of	-
Drawing Dimension	Tolerance		Accept	Reject	Method of Inspection	Comments
-	Tolerance Min	Actual Dimension				Comments
Dimension		Actual Dimension	Accept			Comments
Dimension 0.50	Min	Actual Dimension	Accept			Comments
0.50 1.00	Min Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			Comments
0.50 1.00 5.6	Min Min +0.2/-0.0	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			Comments
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (), 60'' (),0''' (),0'''	Accept			Comments
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080	Min Min +0.2/-0.0 Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080	Min H0.2/-0.0 Min Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept			
0.50 1.00 5.6 0.080 0.050	Min +0.2/-0.0 Min Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept		Inspection	
Dimension 0.50 1.00 5.6 0.080 0.050 Measured by: Audited by:	Min +0.2/-0.0 Min Min	Actual Dimension (.60" 1.04" 5.4" 6.103" 0.060"	Accept		Date:	13/04/16
Dimension 0.50 1.00 5.6 0.080 0.050 Measured by:	Min +0.2/-0.0 Min Min Min	Actual Dimension (),60'' (),04'' (),04'' (),03"	Accept		Inspection Date:	13/04/16 13 4 16 N/A

D3898-1 FLOOR PROTECTOR (206L)

. 99112 MUJ 13-04-02

NOTES:
1) MATÉRIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3898-1" USING VIBRATING STYLUS 7) WEIGHT: 5.0 IDS
8) TOOLING: THERMOFORM PER MOLD DT9501 PER DART QSI 022. TRIM PER MOLD
9) MINIMUM THICKNESS: 0.050" EXCEPT AS SHOWN

A NEW ISSUE 09.02.27 PH REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN CHECKED DRAWING NO. REV. A D3898 MFG. APPR. SHEET 1 OF 2 APPROVED TITLE SCALE FLOOR PROTECTOR (206L)

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